

shp 20/08

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:06:15 PM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SUPPORT ASSY (RH)
<b>Job Number</b>	: 41020	<b>Part Number</b>	: D3699042
<b>Estimate Number</b>	: 13286	<b>Drawing Number</b>	: D3699 REVA
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 06/08/2008 S.O. No. :	<b>Drawing Revision</b>	: A
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: // Type : SMALL /MED FAB	<b>Due Date</b>	: 28/08/2008
<b>Previous Run</b>	: 38873	<b>Qty:</b>	5 Um: Each
<b>Written By</b>	:		
<b>Checked &amp; Approved By</b>	: <u>JLD 08.8.08</u>		
<b>Comment</b>	: Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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3,



**Comment:** Qty.: 0.4797 sf(s)/Unit Total : 0.9595 sf(s)  
6061T6 aluminium sheet .050" thick  
(M6061T6S050)  
Batch: 104186 HB 8-8-7

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3699  
Dwg Rev: A HB 8-8-7  
Prog Rev: A  
\*\*\*grain direction along 9.00" \*\*\*  
2- Deburr if necessary HB 8-8-7

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-8-7



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 8/8/8 (x6)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
Bend as per Dwg D3697

SB 08/08/12

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:15 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (RH)

Job Number: 41020

Part Number: D3699042

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (76)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D3699

FF 08-08-14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-14 (6)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-P 08/08/15

10.0

POWDER COATING

POWDER COATING



M 10 23 16



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15  
320 OF  
3:45

M-P 08/08/18

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-18 (62X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut Plate

batch:

M106042

8/8/19

6x

Scf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:15 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (RH)

Job Number: 41020

Part Number: D3699042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS20426AD33

Rivet



(6X)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch: M1563

08/01/09

SV

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

08/08/20

(6X)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/20 (6X)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SI 184

08/08/21

(46)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



mf 08-08-21

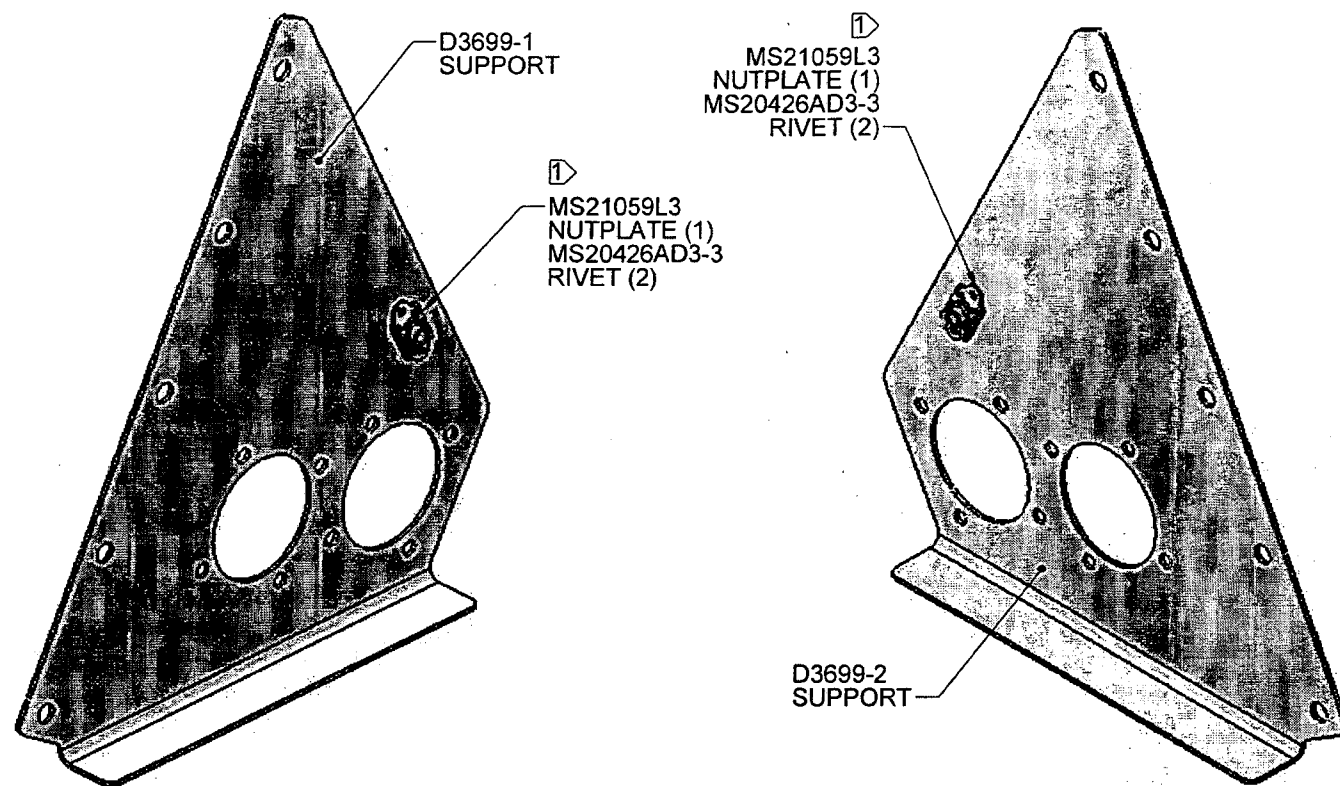
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3699-041 SUPPORT ASSEMBLY**

**D3699-042 SUPPORT ASSEMBLY**

**PART LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

**NOTES:**

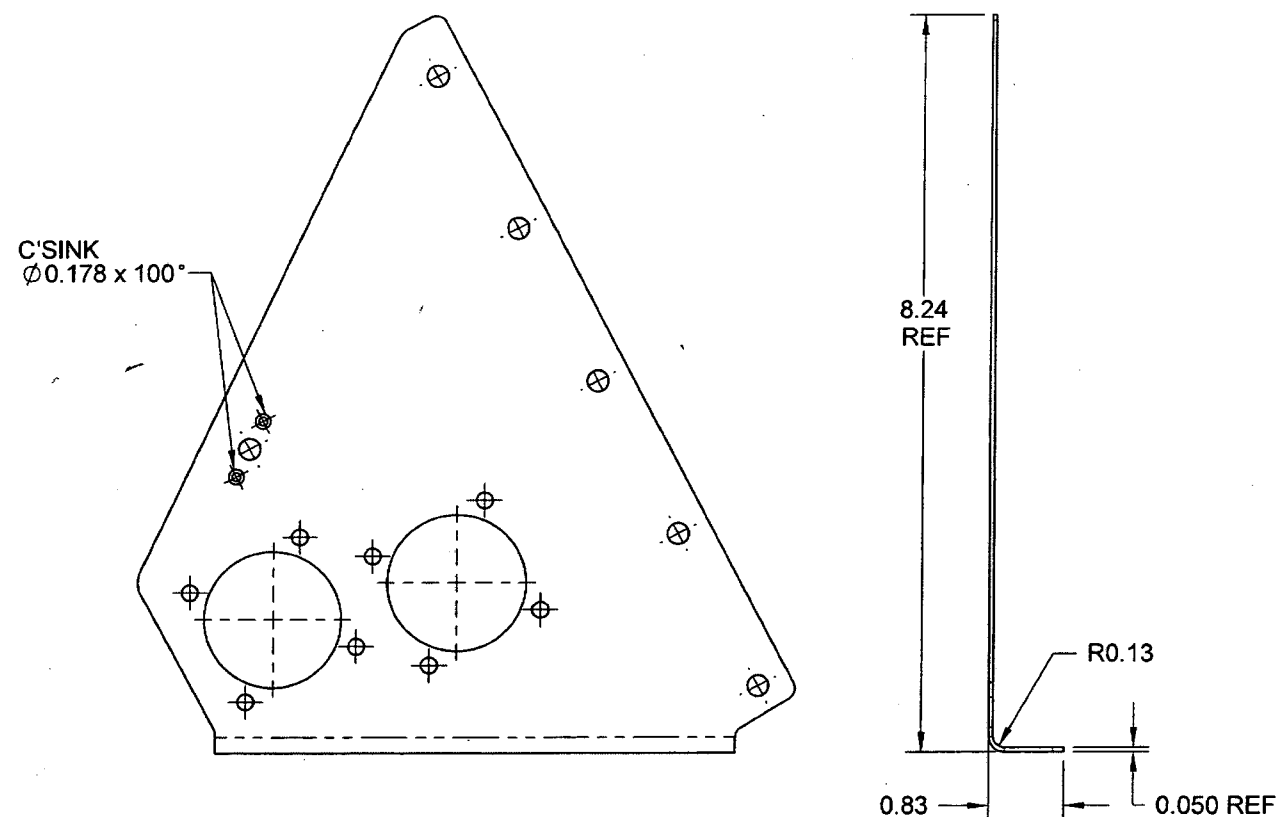
- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK  $\phi 0.098$  HOLES ON D3699-1/-2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

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WORK ORDER  
NO. 41020

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	TH		
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	GP	D3699	SHEET 1 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

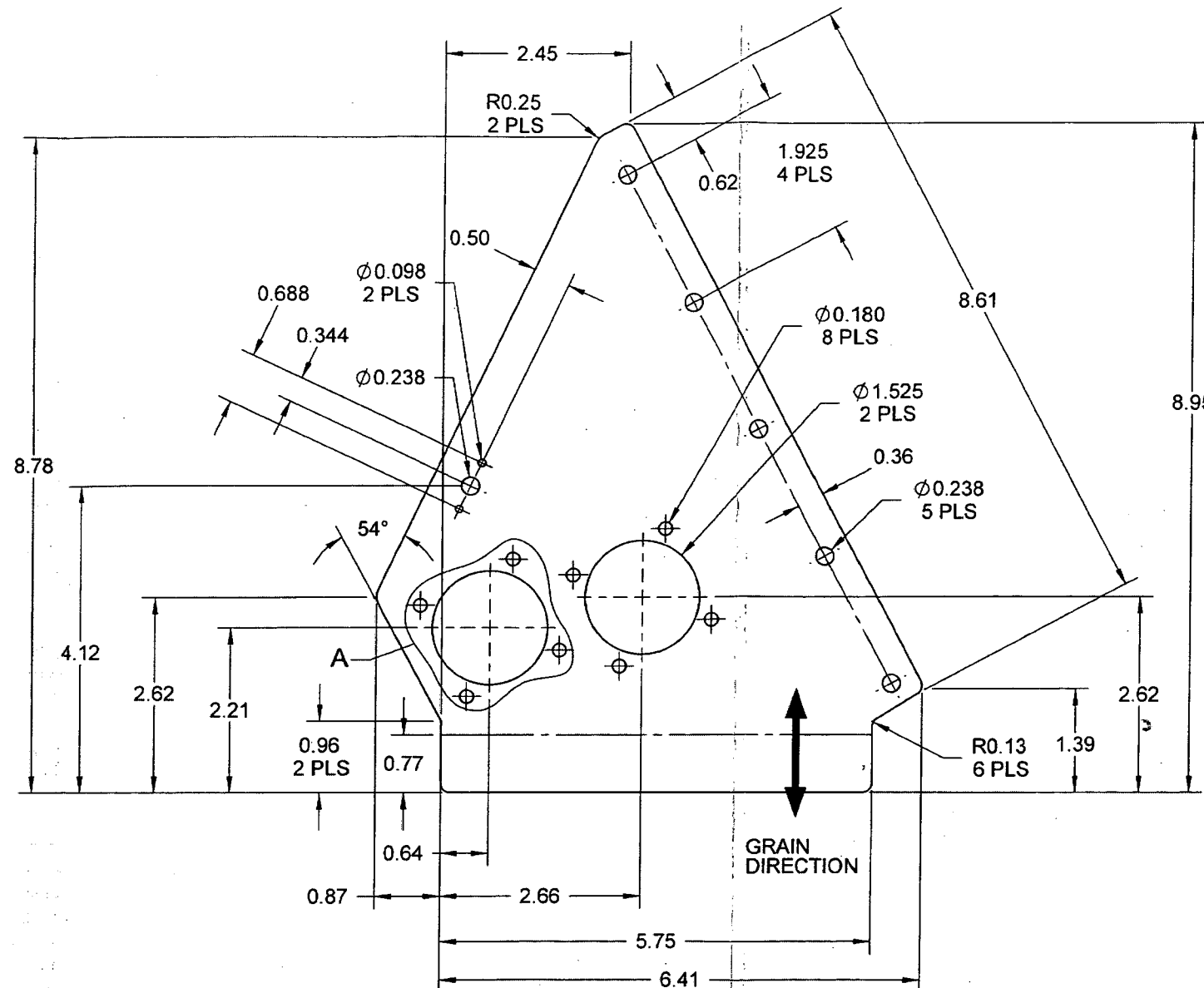
**D3699-1 LH SUPPORT**

**D3699-2 RH SUPPORT**

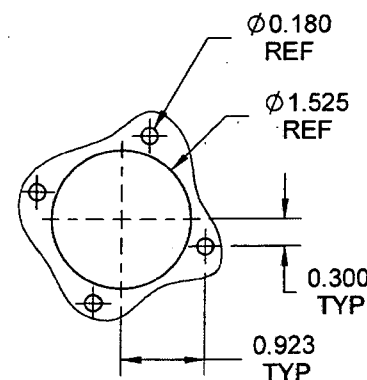


**D3699-1 SUPPORT, LH SHOWN  
(D3699-2 SUPPORT, RH OPPOSITE)  
(MAKE FROM D3699-1F FLAT PATTERN)**

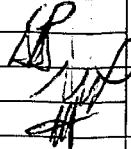
- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.17 lbs



**D3699-1F FLAT PATTERN**



**DETAIL A**

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT ASSEMBLY</b>	NTS
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08-07-08

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WORK ORDER  
NO. 47020



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41020
<b>Description:</b> Support ASS'y		<b>Part Number:</b> D3699-2
<b>Inspection Dwg:</b> D3699-2 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✓			
Ø .180	+ .005 - .001	.183	✓			
Ø .238	+ .005 - .001	.242	✓			
Ø 1.525	+ .012 - .001	1.529	✓			
.36	+/- .030	.363	✓			
.62	+/- .030	.62	✓			
.96	+/- .030	.96	✓			
2.21	+/- .030	2.21	✓			
4.12	+/- .030	4.12	✓			
8.95	+/- .030	8.95	✓			
1.925	+/- .010	1.925	✓			
8.61	+/- .030	8.61	✓			
2.62	+/- .030	2.62	✓			
.344	+/- .010	.344	✓			
.688	+/- .010	.688	✓			
.64	+/- .030	.64	✓			
2.66	+/- .030	2.66	✓			
5.75	+/- .030	5.750	✓			
6.41	+/- .030	6.413	✓			
.300	+/- .010	.301	✓			
.923	+/- .010	.923	✓			
.050	+/- .010	.054	✓			

<b>Measured by:</b> <u>18</u>
<b>Date:</b> <u>8-8-7</u>

<b>Audited by:</b> <u>8</u>
<b>Date:</b> <u>8/8/8</u>

<b>Prototype Approval:</b> <u>2</u>
<b>Date:</b> <u>8</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

P/O D3699-042

*[Signature]*